

Date: Thursday, 13/11/2008 9:07:37 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LARGE SHELF
<b>Job Number</b> : 43111	
<b>Estimate Number</b> : 10881	
<b>P.O. Number</b> :	<b>Part Number</b> : D32521
<b>This Issue</b> : 13/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3252 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43111	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/11/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JO 08.11.13</u>	
<b>Comment</b> : Est. B 04.10.26 D3252-1 no longer made in-house est c 08.11.13 in-house ec verified: DD	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S063	2024-T3 .063 sheet
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**Comment:** Qty.: 2.2743 sf(s)/Unit Total : 4.5486 sf(s)  
 2024-T3 .063 sheet  
 batch: 109463 HB 8-11-13

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3252  
 Dwg Rev: A HB 8-11-13  
 Prog Rev: A

2-Deburr if necessary HB 8-11-13

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/11/14 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Bend as per dwg D3252

SB 08/11/18 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 13/11/2008 9:07:37 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE SHELF

Job Number: 43111

Part Number: D32521

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/18 (x2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

21

08-11-18 x2

8.0

POWDER COATING

POWDER COATING



M10S642



(2x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

3:30 OF

OVEN TEMPERATURE:

320

FINISH TIME:

4:00

MF 08/11/19

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/11/20 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 146

8/11/20

(2x)

SOP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 4311
<b>Description:</b> Large Shelf (Dual Battery Rack)		<b>Part Number:</b> D3252-1
<b>Inspection Dwg:</b> D3252	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

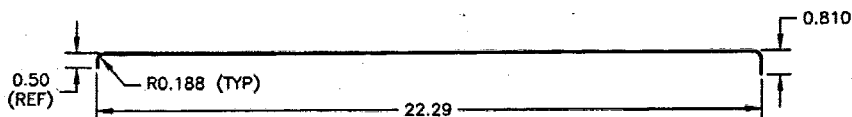
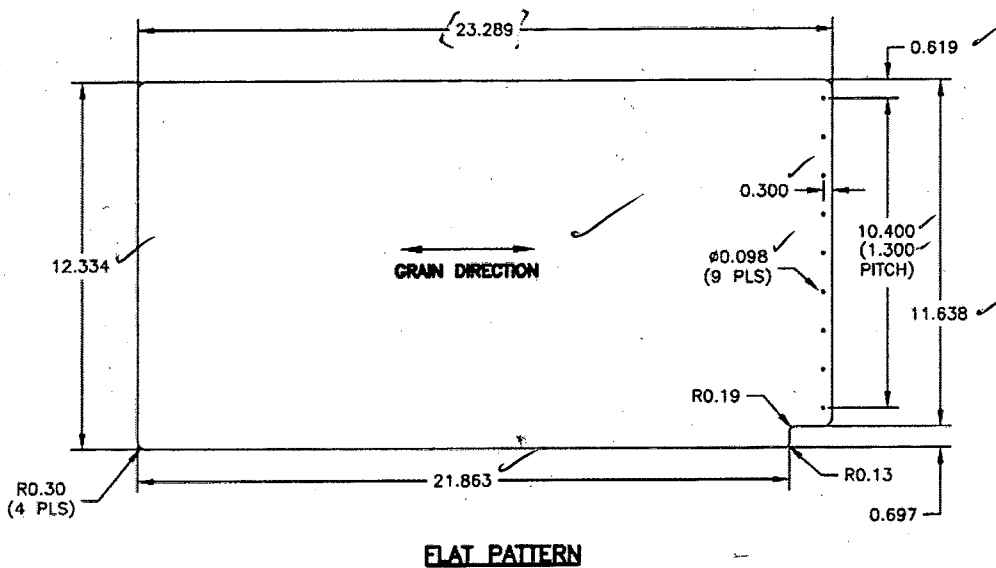
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	X			
0.619	+/-0.010	.617	X			
0.300	+/-0.010	.304	X			
10.400	+/-0.010	10.398	X			
1.300	+/-0.010	1.299	X			
11.638	+/-0.010	11.634	X			
R0.19	+/-0.030	.19	X			
R0.13	+/-0.030	.13	X			
0.697	+/-0.010	.697	X			
21.863	+/-0.010	21.863	X			
R0.30	+/-0.030	.30	X			
12.334	+/-0.010	12.334	X			
Grain along 23.289	N/A					Measured 23.250
Ø .098	+/-0.004	.099	X			

<b>Measured by:</b> HB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-11-13	<b>Date:</b> 08/11/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	P/O D205-579-015 KJ/JLM	[Signature]

**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED RT	DRAWING NO. D3252	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE LARGE SHELF (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

**RELEASED**  
04.05.04**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 4311

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